Thin April 2 or sooner

Work Orde		484	>111P	*814	184	*							Page 1
Revision ID:	D350-578-0	13		Accept	*N	900	040	100)*	Setup	Start	*N	S1*
	Bearpaw		d. 🙃 d.								Stop	*N	S2*
Required Date:	14/03/2012 02/04/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			ust Item I ustomer:	ID:						
Reference:								_		Run	Start	481	
Approvals:		in: MLJ	Date: 12/03/14				ate:				Stop	^N	R1^
	QC:		Date: '	SPC (Y/N):		Da	ate:					*N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	-	Γοοl ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
DSI 9539	В												
100		DOCUMENT CONTRO	DL	0.00					4	-001	ML	J 1	2-3-2
DC Document Control		Memo Photocopy b CHG001	oluefile and type labels per Pl	0.00 PP D350-578-013 and D	OS19539	Sirla	3/28		<u>_</u>				6
105 *40 5 *		Pick Kit		0.00			1						12/03/2
105 Packaging Packaging		Memo		0.00			() J. C)			12/03/2

110

QC4-100% Inspect kits for completeness

110

Quality Control

Memo

	•									,
W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:									:
	_				ļ. 					
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	o DQA	A :	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N	VC Clos	sed:		Date:	<u> </u>
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC			tion B	<u> </u>	Verific		Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
		·								
			·							
								,		
						٠				
	1	1	1 1		,		1			

Work Ord March-14-12 4		484		*814	184*							Page 2	
Item ID: Revision ID:	D350-578-0	13		Accept	*N90	nn4r	1100)*	Setup	Start	*N	S1*	:-==
Item Name:	Bearpaw									Stop	*N	S2*	
Start Date: Required Date	14/03/2012 : 02/04/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Ite								
Reference:			()										
Approvals:	Process Pla	ın:	Date:	Tooling:		Date:			Run	Start	*N	R1*	
	QC: ,		Date:	SPC (Y/N):	<u>.</u>	Date:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp	
120 Packaging		Packaging		0.00				1313	5125	6 4	<i>-</i>	C	, N
Packaging		Memo Identify and Location: PPP Rev:	pack for shipping as per	PPP D350-578-013 and D	9 S19539							10	
130		QC21- Final Inspection	- Work Order Release	0.00						12)	3/2	29	
130 QC Quality Control		Мето		0.00									

MF 12-03-29

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	ROCEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Appróval QC Inspector		
						·					
Part No	•	PAR #:	Fault Ca	itegory:	NCR: Yes	No DQ	\ \:	Date:			
,				tion:							
NCR:		-	WORK OR	DER NON-CONFORMAN	CE (NCR	3)					
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	3 . ↑ Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector		
		Section A	Chief Eng	Chief Eng	Date	Secu	on C	Chief Eng	QC Inspector		
		94.*					•				
					*						
		•		·							

Picklist Print

March-14-12 4:21:04 PM

Work Order ID: 81484

D350-578-013

Parent Item Name: Bearpaw

81484

D350-578-013

Start Date: 14/03/2012

Required Date: 02/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Parent Item:

IPP REV:A 11.01.04 NEW ISSUE VERF:JLM

11.03.03 AS PER DSI9539 REV.B DD verf:EC

IPP Rev:B

Component I Item Name	tem ID/	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		Date Issued	Status
D2182B050	\		Manufactured	No			105°	Each	18.0000	6	36	/		60
* D218 Clamp Cushion		50* med	5713728							**	13932	JB		3
Cutenter	intet @	Sight lone	•		Location	!	Loc	<u>Oty</u>	Loc Code					
> D218		the second of the second			ST402			18		•		_		
46						79824		18						
D2274			Manufactured	No			105	Each	75.0000	12	$^{^{^{}}})^{72}$		_	
Radius Block	4*,									**	1823	<u> 3 </u>	3	-54)
·					Location	!	Loc	<u>Oty</u>	Loc Code			•		
					ST007			75		_		_		
						72121		32		_		_		
D2529			Manufactured	No		78589 /	105	43 Each	297.0000	12	. 70	_		κħ.
~ ~	\^+		Manufactured	110		•	103	Lacii	297.0000	**	72	V		2011
*D252 Washer	' 9^									19)	(8187)	3 <u>JB</u>		-554
•					Location	ļ.	Loc	Qty	Loc Code					/
					ST010			297				_		
						66953		2		_		~		
,						79221 79485		155 140		43 X	7948	5		
						77703		170		701_	1 1 10	Ø.		

W/O:		· · · · · · · · · · · · · · · · · · ·	V	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										,
								<u> </u>		
					,			:	\$47.	
		٠.			ļ					
Part No		PAR #:	Fault Cat	tegory:	NCR:	Yes f	lo DQ	A:	_ Date: _	
	R	esolution:	Dispositi	ion:	QA: N	/C Clo	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR				
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti	on C	Chief Eng	QC Inspector
•	·									
		·								
								,	7-1	

W/O:	<u> </u>		W	ORK ORDER CHANGI	ES				-
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1.14	
	}								
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQA :		Date:	
	R	esolution:	Disposition	on:	QA: N/C Cl	osed:		Date: _	
NCR:		\	WORK ORE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	ı C	Chief Eng	QC Inspector
					,				
									,
				•					

Picklist Print March-14-12 4:21:04 PM								Page 3
Work Order ID: 81484 Parent Item: D350-578-01 Parent Item Name: Bearpaw			1484* 350-578-0)13*		Start Date: 14/03/20 Start Qty: 6.00	12 Required Date: Required Qty:	
*NAS-1149D0 *NAS-1149D0 Washer	Purchased 463.1*	No		105	Each	3,048.000		
- Washer			Location ST297 121011 ST298 116805 118384 119097 120644	<u>Lo</u>	2000 2000 2000 1048 0 25 169 854	Loc Code		
MS21042L4 *MS21042L4 *DNut	Purchased *	No		105	Each	5,585.000 (12) 72		
			Location ST300 117441 117601 117885	<u>Lo</u>	5585 51 157	<u>Loc Code</u>		

 ST300
 5585

 117441
 51

 117601
 157

 117885
 16

 118451
 133

 119017
 232

 119075
 2996

 121011
 2000

12/03/28

W/O:			WC	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									PTOG WIGH	
									i.	
					,					
				•						
Part No	• •	PAR #:	Fault Cate	gory:	NCF	l: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			· · ·
D.4.T.E. *	OTED	Description of NC			ction B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
										•
·										

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER

AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER

REF. TCCA STC: SH93-4 REF. FAA STC: SR00028NY REF. FAA STC: SR00029NY REF. EASA STC: 10016984

1.0 PURPOSE

The purpose of this DSI is to add the D350-578-013 Bearpaw Kit, which is similar to the existing D350-578-011 Bearpaw Kit, except that the machined pockets have been removed per customer preference. The D350-578-013 Kit installs in the same way as the D350-578-011 Kit.

2.0 INSTALLATION PROCEDURE

2.1 Jack up the aircraft. Ensure the skidtubes are serviceable.

- 2.2 If the Bearpaws are being installed on Dart Skidtubes remove the D3537-1 or D2648-1 Wearpads pior to installing the bearpaws. It is not necessary to remove the Dart Wearplates and gaskets. Re-install attachment hardware into open inserts.
- 2.3 Position the D4297-1 Bearpaw on the aft end of each skidtube as shown in Figure 2.

2.4 Install the D2438 clamps with the hardware as shown in Figure 3.

Caution: The torque on the nuts should be limited to 20 in-lb (2.3 Nm).

2.5 The D4297-1 Bearpaw may be relieved to clear wearshoe mounting screws provided the relief leaves 0.375" (9.53mm) thickness.

ADD AN4-20A

DE APPR.

2.6 Lower the aircraft.

3.0 WEIGHT AND BALANCE

Installation	Weight	La	teral	Longitudinal			
	Weight	Arm	Moment	Arm	Moment		
D350-578-013 Bearpaw Kit	17.60 lb 8.00 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157.0 in 3.99 m	2763.2 in-lb 31.92 m-kg		

4.0 PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
Х	D350-578-013	Bearpaw Kit
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
6	D2438	Clamp
2	D4297-1	Bearpaw
12	AN4-17A	Bolt
12	AN4-20A	Bolt
12	NAS1149D0463J	Washer
12	MS21042L4	Nut or (MS21042-4)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

12/03/14

11.02.25

NTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

BY D. SHEPHERD (DE # 02)

DATE: 11.02.25 CERT. NO.: SH93-4 ISSUE NO .:

		_		, , ,	
Α	NEW ISS	SUE		RF	10.12.15
REV.			DESCRIPTION	BY	DATE
DESIGN	1	RF	DART AFR	ROSPACEL	TD
DRAWN	1	RF,		, ONTARIO, CANA	
CHECK	ED	-#-	DRAWING NO.		REV. B
MFG. A	PPR.	NA	DSI 9539		SHEET 1 OF 3
APPRO	VED	-#	TITLE		SCALE

BEARPAW KIT COPYRIGHT @ 2010 BY DART AEROSPACE LTD DATE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. 11.02.25

W/O:			V	VORK ORDER CHANG	GES		·		
DATE	STEP	PRO	CEDURE CH	IANGE	RK ORDER CHANGES By Date Qty Approval Chief Eng / Prod Mgr QC Inspector NCR: Yes No DQA: Date: QA: N/C Closed: Date:				
			•						
									:
							:		
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Ye	s No C	QA:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Closed:		Date: _	
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NO	R)			
DATE	CTED	Description of NC	Initial Action Description Sign & Section C Chief Eng QC In	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& _S ,		Chief Eng	QC Inspector
		·							
					1				
r									
			1			ı			i

^{*}H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

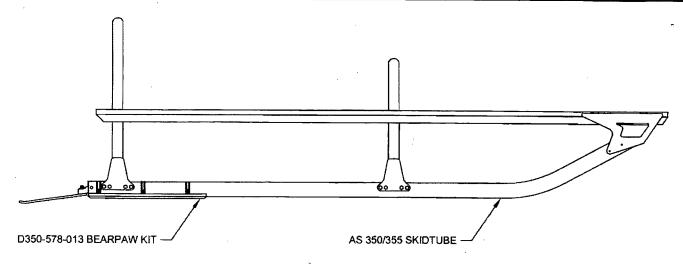
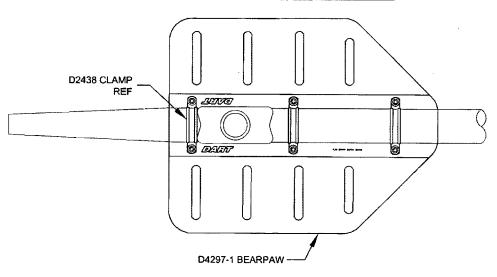
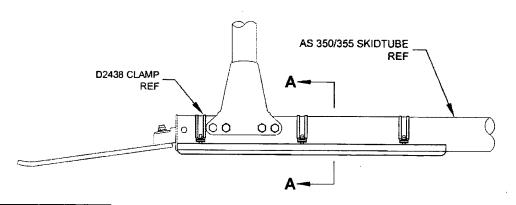


Figure 1. D350-578-013 Bearpaw Kit





11.02.25

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: APPROVED
D. SHEPHERD (DE # 02)

DATE: 11.02.25 CERT. NO.: SH93-4 ISSUE NO.: 8

Figure 2. Bearpaw Location (Side View & top View)

DESIGN RF		DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	#	DRAWING NO.	REV. B		
MFG. APPR.	N/A	DSI 9539	SHEET 2 OF 3		
APPROVED ·	AH.	TITLE	SCALE		
DE APPR.		BEARPAW KIT	NTS		
DATE 440	2 25	COPYRIGHT @ 2010 BY DART	NEROSPACE LTD		

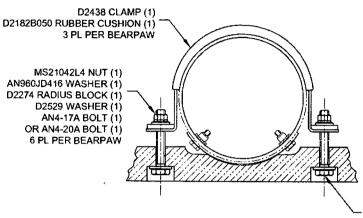
COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

WRITTEN PERMISSION FROM DART AEROSPACE LTD.

	-								
W/O:			WC	ORK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
							<u> </u>		<u> </u>
Part No		PAR #:							
		Disposition: QA			 		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
									:
i 									
					·				
,	1								



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Figure 3. Clamping Detail (Section A-A)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

DATE: CERT. NO.: ISSUE NO.:

DESIGN	RF	DART AEROSPACE LTD				
DRAWN	RF,	HAWKESBURY, ONTARIO, CANADA				
CHECKED	-#	DRAWING NO.	· REV. B			
MFG. APPR.	N/A	DSI 9539	SHEET 3 OF 3			
APPROVED	#	TITLE	SCALE			
DE APPR.	#	BEARPAW KIT	NTS			
DATE 11.02.25		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PROSECULATION IT.				

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:			V	VORK ORDER CHANG	ES			•	
DATE	STEP	PRO	WORK ORDER CHANGES By Date Qty Chief Eng / Prod Mgr Approval Chief Eng / Prod Mgr Action Section B Corrective Action Section B Chief Eng Approval QC Inspector						
						····			
Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/C C	osed:		Date:	<u>-</u>
NCR:		V	WORK OR	DER NON-CONFORMA	NCE (NCF	?)			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	Description of NC))			Verifi	cation	Approval	Approval
DAIL	SIEF	Section A		Action Description Chief Eng		I OCC	ion C	Chief Eng	QC Inspector
							· 		
•									

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER

REF. TCCA STC: SH93-4 REF. FAA STC: SR00028NY REF. FAA STC: SR00029NY REF. EASA STC: 10016984

REFERENCE ONLY

1.0 PURPOSE

The purpose of this DSI is to add the D350-578-013 Bearpaw Kit, which is similar to the existing D350-578-011 Bearpaw Kit, except that the machined pockets have been removed per customer preference. The D350-578-013 Kit installs in the same way as the D350-578-011 Kit.

2.0 INSTALLATION PROCEDURE

2.1 Jack up the aircraft. Ensure the skidtubes are serviceable.

- 2.2 If the Bearpaws are being installed on Dart Skidtubes remove the D3537-1 or D2648-1 Wearpads pior to installing the bearpaws. It is not necessary to remove the Dart Wearplates and gaskets. Re-install attachment hardware into open inserts.
- 2.3 Position the D4297-1 Bearpaw on the aft end of each skidtube as shown in Figure 2.

2.4 Install the D2438 clamps with the hardware as shown in Figure 3.

Caution: The torque on the nuts should be limited to 20 in-lb (2.3 Nm).

- 2.5 The D4297-1 Bearpaw may be relieved to clear wearshoe mounting screws provided the relief leaves 0.375" (9.53mm) thickness.
- 2.6 Lower the aircraft.

3.0 WEIGHT AND BALANCE

Installation	\A(a)abt	Lateral Lateral		Longitudinal		
Installation	Weight	Arm	Moment	Arm	Moment	
D350-578-013 Bearpaw Kit	17.60 lb 8.00 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157.0 in 3.99 m	2763.2 in-lb 31.92 m-kg	

4.0 PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
X	D350-578-013	Bearpaw Kit
6	D2182B050	Rubber Cushion
7 12	D2274	Radius Block
1 12	D2529 5	Washer
/ 6	D2438 [′]	Clamp
7 2	D4297-1	Bearpaw
/ 12	AN4-17A 67	Bolt
12 (ے	AN4-20A	Bolt
/ 12	NAS1149D0463J /	Washer
/ 12	MS21042L4	Nut or (MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

DATE: 11.02.25
CERT. NO.: SH93-4
ISSUE NO.: 8

В	ADD AN	RF	11.02.25				
Α	NEW IS	NEW ISSUE R					
REV.		BY	DATE				
DESIGN RF			DART AEROSPACE LTD				
DRAWN RF.		RF,	HAWKESBURY, ONTARIO, CANADA				
CHECKED		#-	DRAWING NO.		REV. B		
MFG. APPR.		MA	DSI 9539		SHEET 1 OF 3		
APPROVED -		-#	TITLE		SCALE		
DE APPR.		-#	BEARPAW KIT				
DATE 11.02.25			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONTION THAT IT IS NOT TO BE USED FOR ANY DIMPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT				